

Blue

Work Order ID 81804

81804

March-19-12 1:34:32 PM

Item ID: D2933-2 Accept *N9000040100** Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Saddle RH In, 206
Start Date: 19/03/2012 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 18/05/2012 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: MLJ Date: 12/03/19 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2933	Rev C								

100 HAAS CNC VERTICAL MACHINING #1 0.00
100 HAAS 1 Memo 0.00 FK-12/04/30 8 0
HAAS CNC vertical machine #1 Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per PO 12/05/01

110 CONVENTIONAL MILLING MACHINE 0.00
110 Mill Conv Memo 0.00 FK-12/04/30 8 0
Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet PO 12/05/01

120 QC1- Inspect dimensions to dimension sheet 0.00
120 QC Memo 0.00 FK-12/04/30 8 0
Quality Control PO 12/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 19/03/2012 **Start Qty:** 8.00 ***g***

Cust Item ID:

Required Date: 18/05/2012 **Req'd Qty:** 8.00 ***O***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

QC8- Inspect parts - second check

0.00

B.A 12/05/02

QC

Memo

0.00

Quality Control

Chemical Conversion Coat per QSI005 4.1

0.00

8 ~~0~~ BL 1252

HandFinish

Memo

0.00

Hand Finishing

155

SprayPaint

Spray Painting

Blue prime: $\frac{117319}{0.00}$
Memo del ficut blue: $\frac{121149}{0.00}$
Near: $\frac{118093}{0.00}$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81804***81804***

Page 3

March-19-12 1:34:32 PM

Item ID: D2933-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle RH In, 206
Start Date: 19/03/2012 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 18/05/2012 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
165 *165* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				8		12.05.11	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>421</u> Memo	0.00 0.00							12/5/11 8
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/5/14 J

12-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-19-12 1:34:36 PM

Page 1

Work Order ID: 81804

81804

Parent Item: D2933-2

D2933-2

Parent Item Name: Saddle RH In, 206

Start Date: 19/03/2012

Required Date: 18/05/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001		Manufactured	No			100	Each	53.0000	1	8			
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D6101-001

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

3

69677

2

76836

1

MAT041

50

80764

50

81923

8

FK 12/04/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	E1804
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.125	0.125	0.126	0.125		
B	0.100	0.140		0.125	0.125	0.127	0.124		
C	0.100	0.140		0.119	0.117	0.119	0.119		
D	0.210	0.230		0.222	0.220	0.218	0.218		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.236	0.236	0.236	0.237		
N	0.100	0.140		0.121	0.120	0.119	0.120		
O	0.540	0.560		0.550	0.550	0.548	0.548		
P	0.490	0.510		0.498	0.503	0.498	0.498		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.494	2.494	2.494	2.494		
S	0.240	0.270		0.251	0.250	0.250	0.250		
T	0.100	0.180		0.135	0.138	0.135	0.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.316	0.316	0.316	0.316		
X	1.125	1.145		1.135	1.135	1.134	1.134		
Y	1.565	1.585	DT8695 A/B	1.574	1.574	1.574	1.575		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	FK / PD
Date:	12/04/30

Audited by:	B.A
Date:	12/05/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	E1804
Description: 206 Saddle, Inboard, Right side		Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1	

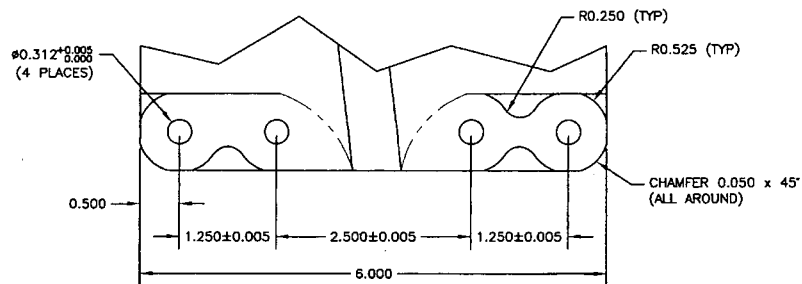
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 ₅	2 ₆	3 ₇	4 ₈		
A	0.100	0.140		0.125	0.125	0.125	0.125		
B	0.100	0.140		0.125	0.125	0.125	0.124		
C	0.100	0.140		0.117	0.117	0.117	0.114		
D	0.210	0.230		0.219	0.219	0.222	0.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.512	0.512	0.513	0.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
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K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.235	0.236	0.237	0.236		
N	0.100	0.140		0.119	0.122	0.121	0.121		
O	0.540	0.560		0.548	0.549	0.549	0.548		
P	0.490	0.510		0.500	0.500	0.497	0.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.494	2.494	2.494	2.494		
S	0.240	0.270		0.250	0.250	0.250	0.251		
T	0.100	0.180		0.135	0.135	0.135	0.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.316	0.316	0.316	0.316		
X	1.125	1.145		1.135	1.136	1.135	1.137		
Y	1.565	1.585	DT8695 A/B	1.574	1.575	1.575	1.576		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	Po
Date:	12/05/01

Audited by:	h.a
Date:	12/05/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

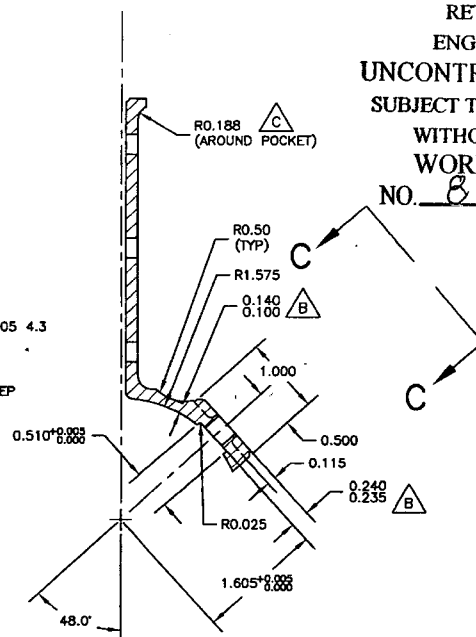


VIEW C-C

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

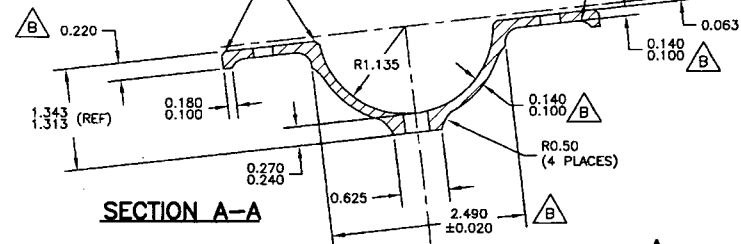
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM 06101-001 SADDLE BULLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



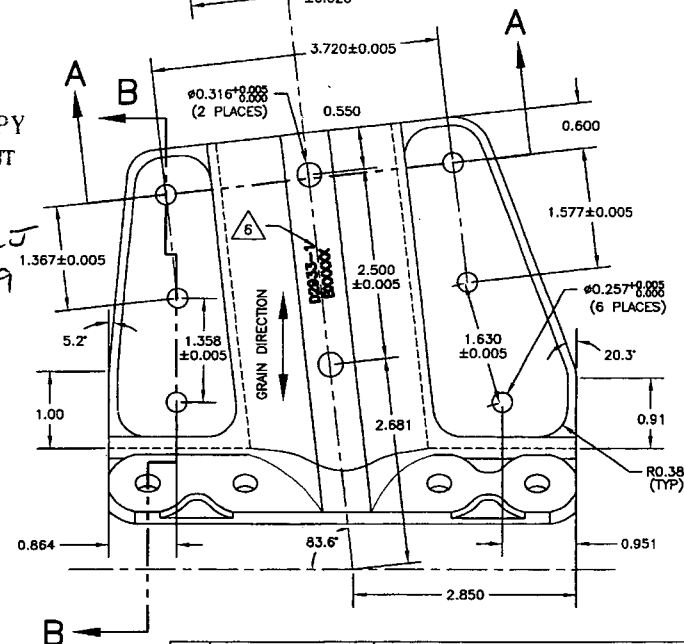
SECTION B-B

CHAMFER 0.050 x 45° AROUND
THIS SURFACE (TYP 2 PLACES)



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81804 MLJ
12/03/19



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2933
DATE		TITLE SADDLE INSIDE
06.11.09		REV. C SHEET 1 OF 1 SCALE 2:3

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DART AEROSPACE USA, INC.

07.02.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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